

Date: Wednesday, 1/18/2006 4:03:43 PM
 User: Kim Johnston

Process Sheet

(4)

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HIGH AFT X-TUBE 412
 Job Number : 25550
 Estimate Number : 10559
 P.O. Number :
 This Issue : 1/18/2006 S.O. No. :
 Prsht Rev. : NC Part Number : D412664203
 First Issue : N/A Type : LANDING GEAR Drawing Number : D412-664-243 REV B
 Previous Run : 25549 Drawing Revision : B
 Material : N/A
 Due Date : 2/20/2006 Qty: 1 Um: Each
 Written By : SEE COMMENT BELOW
 Checked & Approved By : SEE ABOVE DATE & USER
 Comment : Est Rev:E 04.02.16 Reformat; Added D3189-1 K/DS

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D412-664-203 CHG 003

KR 06-02-23

2.0 D6009129 Crosstube Material



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6009-129 Crosstube 321024

Check OD = 3.500"; ID = 2.250"

ml 06/02/01

3.0 MORI SEIKI MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA166

2-Turn first side as per Folio FA166

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-243.

ml 06/02/01

4.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

ml 06/02/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/18/2006 4:03:43 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH AFT X-TUBE 412

Job Number: 25550

Part Number: D412664203

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA166

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-243.

3-Polish entire outside surface of crosstube

4- Remove sand and plugs

5-Scribe part # and batch # using vibrating stylus as per Dwg D412-664-243

J.F 06/02/03

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

J.F 06/02/03

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.G 06/02/03

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

a.m 06-02-03 ①

9.0

QC3/5

INSPECT WORKWING WALK



Comment: Inspect work & Chemical conversion Coat

DP 06-2-13 ①

10.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D412-664-243 using CNC bender program 412-af and Folio FT010

DP 06-2-14 ①

11.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

John 15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

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User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH AFT X-TUBE 412

Job Number: 25550

Part Number: D412664203

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube as per Dwg D412-664-243 using drill Jig DT8550 & DT8551

Pm 06-02-150

2-Ream hole to finish size in tube as per Dwg D412-664-243 using drill Jig DT8550 & DT8551. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes.

Pm 06-02-150

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-243

Pm 06-02-150

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M 02 16

14.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038 Or

Issue P/O: *609* LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

A 060217

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

C 206102121 ①

16.0

QC6

DIMENSIONAL CHECK



Comment: Inspect for damage & ensure results are as per Dwg D412-664-203

060223 1

17.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

M 06 02 24

2-Paint outside crosstube with White Imron as per QSI 005 4.2

M 06 02 25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH AFT X-TUBE 412

Job Number: 25550

Part Number: D412664203

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

QC14

Inspect Spray Paint



DP06-2-27

Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

19.0

D2856600

Abrasion Strip



Comment: Qty.: 1.7640 f(s)/Unit Total : 1.7640 f(s)

Pick:

Qty Part number Description Batch

2 D2856-600(Cut to 10.090") Abrasion Strip

B24328

DP06-2-27

20.0

D2856600

Abrasion Strip



Comment: Qty.: 1.0080 f(s)/Unit Total : 1.0080 f(s)

Pick:

Qty Part number Description Batch

1? 2 D2856-600(Cut to 10.870") Abrasion Strip

B24328

DP06-2-27

21.0

D28961

Support



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D2896-1

Support

B21740

DP06-2-27

22.0

D31891

Chafing Shield



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D3189-1

Chafing Shield

B24860

DP06-2-27

23.0

MS2192028

Clamp



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-28

Clamp

41720

DP06-2-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/18/2006 4:03:44 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH AFT X-TUBE 412

Job Number: 25550

Part Number: D412664203

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

MS2192030

Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 MS21920-30

Clamp

M15921

DP06-2-27

25.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

26.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

27.0

AN640A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part number Description Batch

410 AN6-40a

Bolt

m18254

28.0

AN641A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part number Description Batch

2 AN6-41A

Bolt

m17231

29.0

AN960JD616

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick: Packing Kit

Qty Part number Description Batch

18 AN960JD616

Washer

m19098

30.0

MS21042L6

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick: Packing Kit

Qty Part number Description Batch


6 MS21042L6

Nut

m19099

C206102127 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 26/03/01

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/18/2006 4:03:44 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH AFT X-TUBE 412

Job Number: 25550

Part Number: D412664203

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

PC 6/2/28

32.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-664-203

Location: _____

PPP Rev: C

C Log 10-21-28 ①

33.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/03/01

Job Completion



U 06-03-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D'ART AEROSPACE LTD		Work Order:	25590
Description: Crosstube Assembly (412 High Aft)		Part Number:	D412-664-243
Inspection Dwg: D412-664-243 Rev: A1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.684	+0.005/-0.000	2.689	✓			
	2.748	+0.005/-0.000	2.753	✓			
	2.884	+0.005/-0.000	2.889	✓			
	3.019	+0.005/-0.000	3.024	✓			
	3.163	+0.005/-0.000	3.168	✓			
	3.308	+0.005/-0.000	3.313	✓			
	3.429	+0.005/-0.000	3.434	✓			
	2.990	+0.005/-0.000	2.991	✓			
	2.618	+0.005/-0.000	2.623	✓			
	0.200	+/-0.010	0.205	✓			
	R0.063	+/-0.010	R0.063	✓			
	R0.500	+/-0.010	R0.500	✓			
	4.971	+/-0.001	4.971	✓			
SIDE B	2.684	+0.005/-0.000	2.689				
	2.748	+0.005/-0.000	2.753				
	2.884	+0.005/-0.000	2.889				
	3.019	+0.005/-0.000	3.024				
	3.163	+0.005/-0.000	3.168				
	3.308	+0.005/-0.000	3.313				
	3.429	+0.005/-0.000	3.434				
	2.990	+0.005/-0.000	2.991				
	2.618	+0.005/-0.000	2.623				
	0.200	+/-0.010	0.200"				
	R0.063	+/-0.010	0.063"				
	R0.500	+/-0.010	0.500				
	4.971	+/-0.001	4.971				
	124.09	+/-0.020					

Measured by: <i>ML/JF</i>	Audited by: <i>J.G.</i>	Prototype Approval:	N/A
Date: <i>06/02/03</i>	Date: <i>06/02/03</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.16	New Issue (P/O D412-664-203)	KJ/JLM	



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D412-664-243	REV. B SHEET 1 OF 3
DATE 05.02.04		TITLE CROSSTUBE ASSEMBLY (412 HI AFT) NTS	
A	01.10.17	NEW ISSUE	
B	05.02.04	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

RELEASED
05.06.09 [Signature]

Qty	Part Number	Description
X	D412-664-243	CROSSTUBE ASSEMBLY (412 HIGH AFT)
1	D6009-129	CROSSTUBE
1	D2896-1	SUPPORT
2	D2856-600-1009	ABRASION STRIP
1	D2856-600-1087	ABRASION STRIP
4	MS21920-28	CLAMP
2	MS21920-30	CLAMP
2	D3189-1	CHAFING SHIELD

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6009-129
FINISHED LENGTH = 124.09±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-600-1009 AND D2856-600-1087 ABRASION STRIPS WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2896-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTINAL TO TO SEAL EDGES OF SUPPORTS USING SIKAFLEX-241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

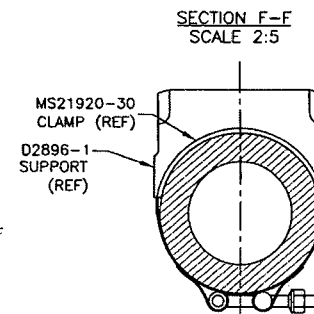
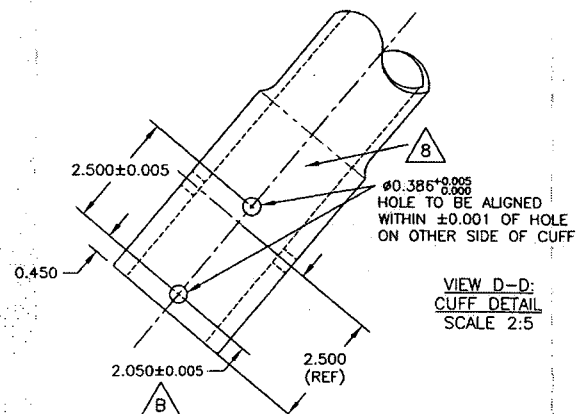
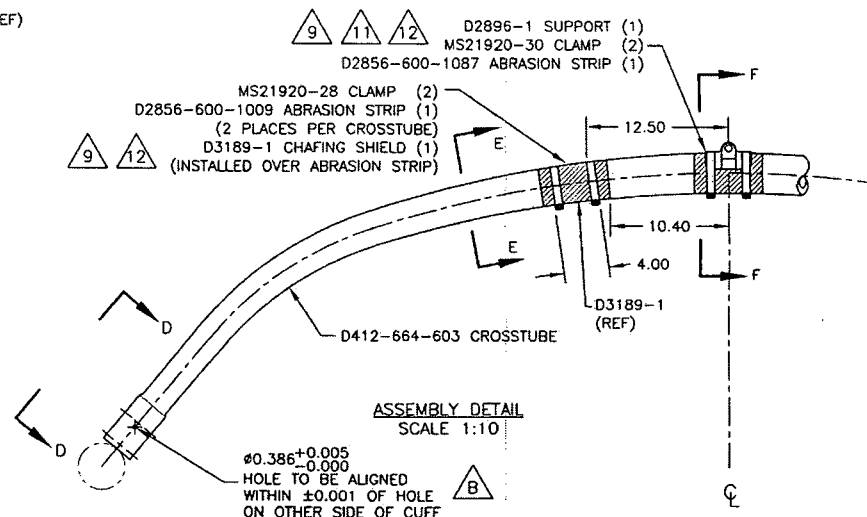
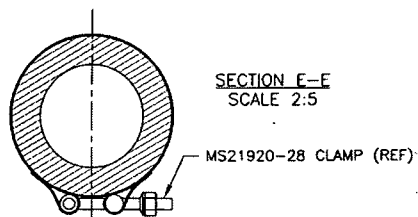
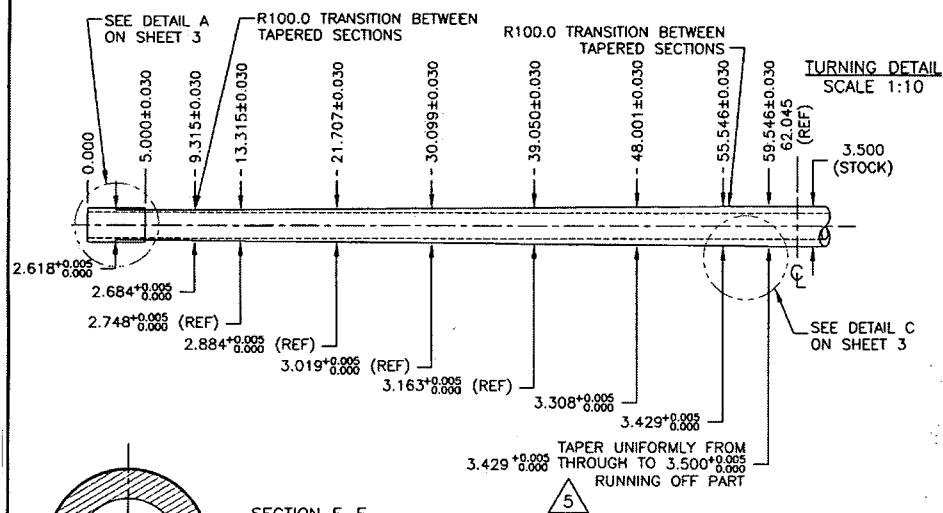
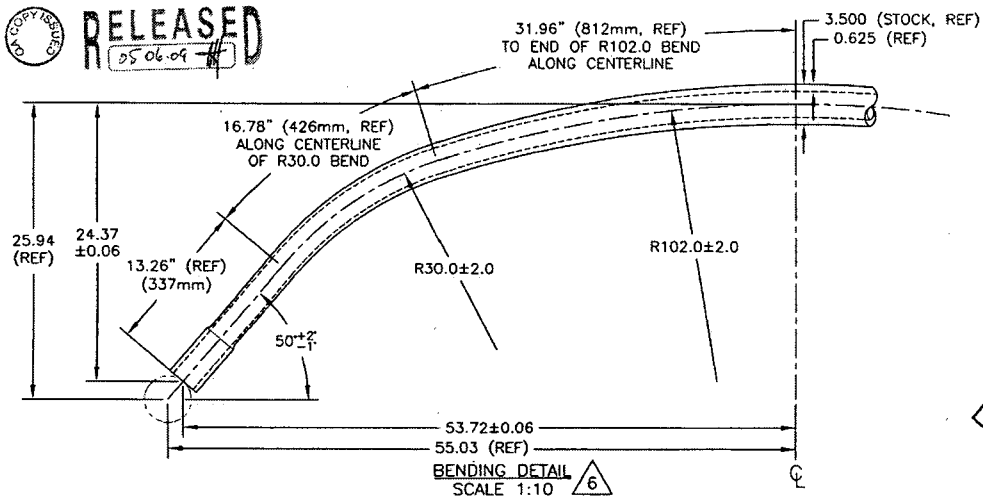
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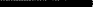
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SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 25550

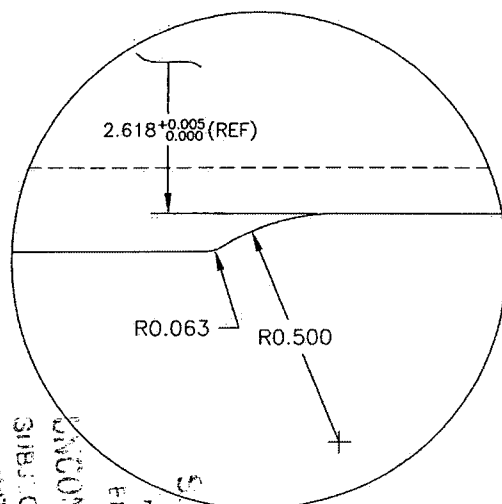
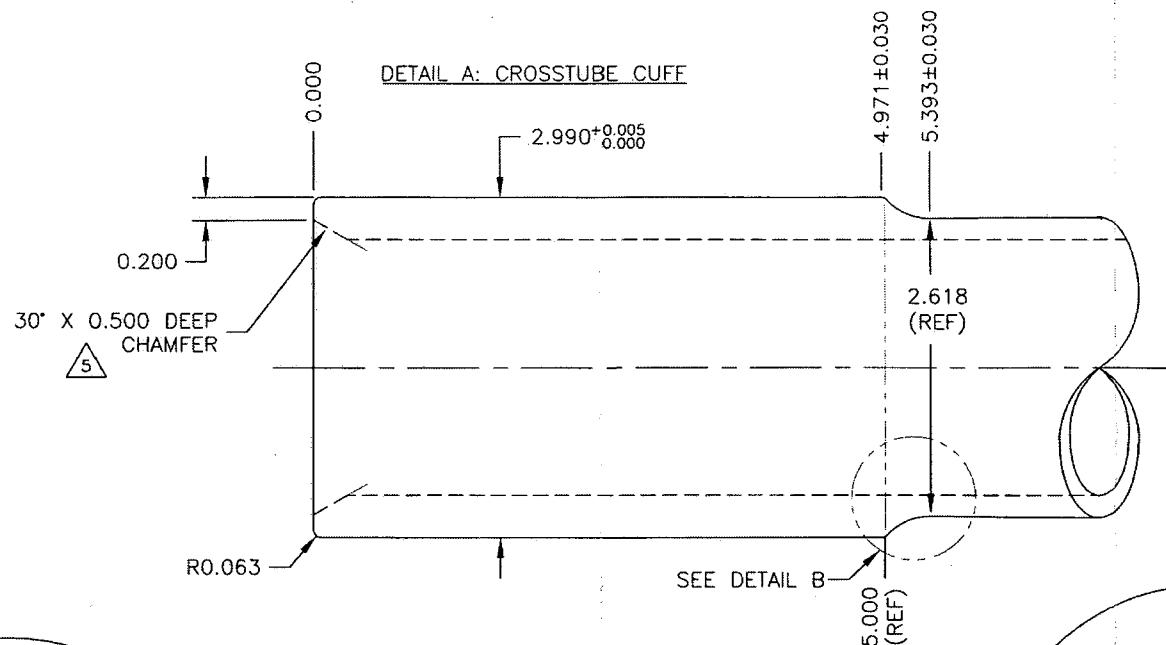
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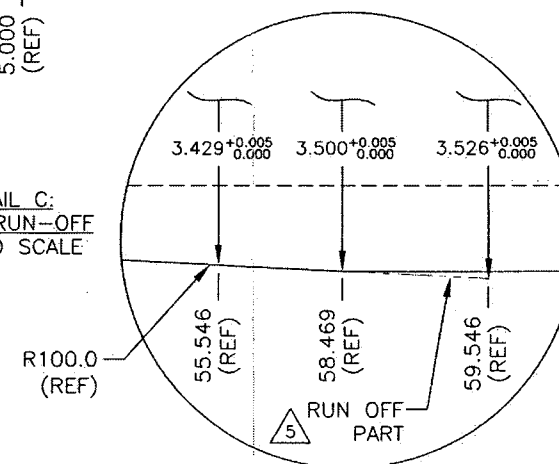
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						D412-664-243	SHEET 2 OF 3
		DATE				TITLE	SCALE
		05.02.04				CROSSTUBE ASSEMBLY (412 HI AFT)	1:10

RELEASED
65.06.09



DETAIL B: CUFF
TRANSITION
SCALE 4:1

DETAIL C:
TAPER RUN-OFF
NOT TO SCALE

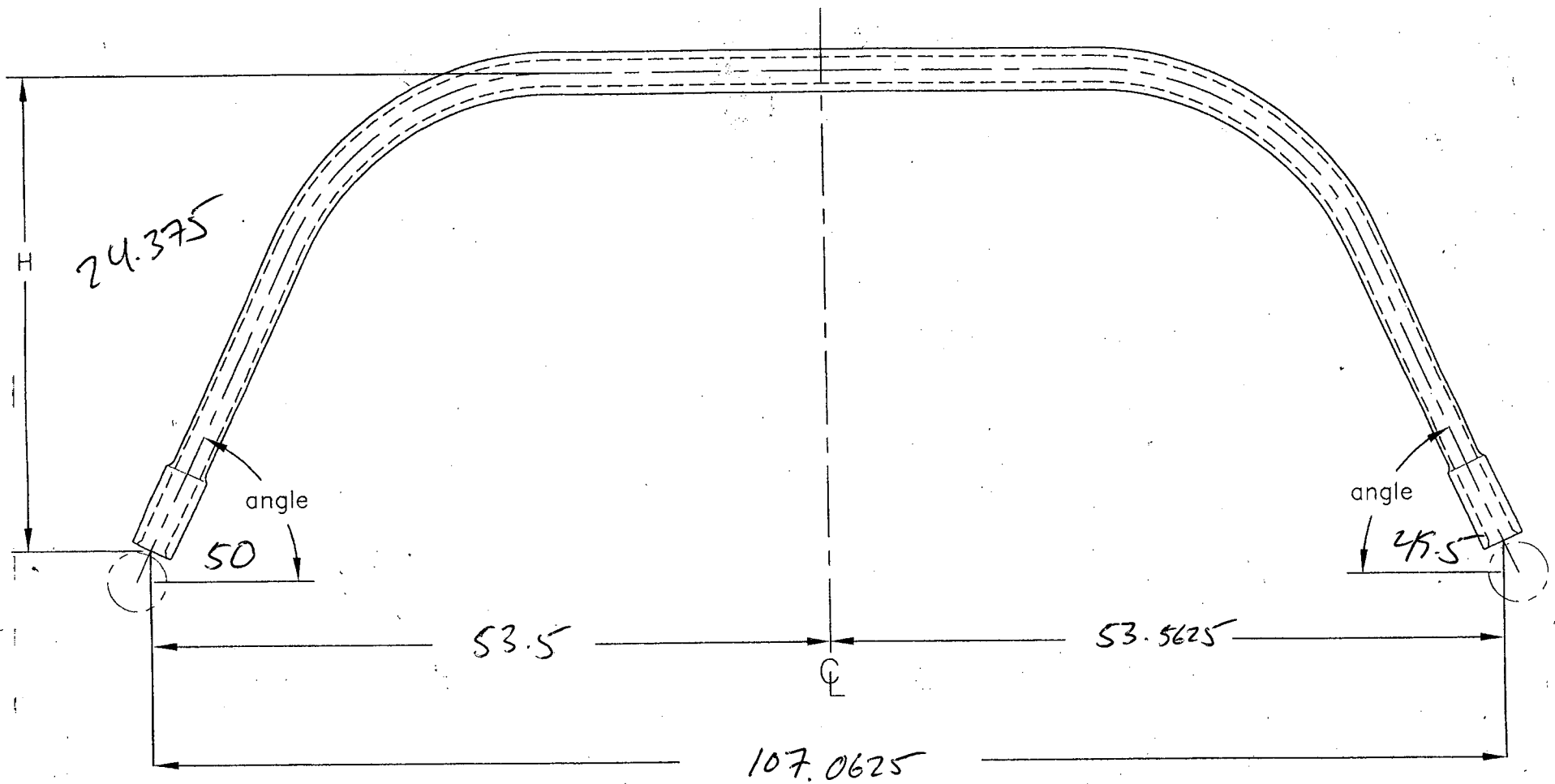


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DESIGN PH	DRAWN BY PH	DART	DART AEROSPACE LTD. WILMINGTON, ONTARIO, CANADA
CHECKED PH	APPROVED PH	DRAWING NO. D412-664-243	REV. B SHEET 3 OF 3
DATE 05.02.04	TITLE CROSSTUBE ASSEMBLY (412 HI AFT)	SCALE 1:1	

NO. 23860
WORK ORDER
SUBJECT TO A. M. N.
WITHOUT NOTICE
UNCONTROLLED COPY
ENGINEERING
PLANTING
SALES COPIES



DATE: 06-02-15

DESCRIPTION: D412-664-203

BATCH NO: 25550

DRAWING: D412-664-243

H: 24.37

1/2 SPAN: 53.72

TOTAL SPAN: 107.44

ANGLE: 50°

[Signature] 06-02-15

~~REVISION~~

Linda Lacelle

From: David Shepherd [davids@dartaero.com]
Sent: Wednesday, February 15, 2006 10:46 AM
To: Jason Murdoch
Cc: Linda Lacelle
Subject: Re: 412 x-tube

Jason/Linda

D412-664-203 B25550 is acceptable.

David

----- Original Message -----

From: "Dan Stow" <dstow@dartaero.com>
To: "Davids@Dartaero.Com (E-mail)" <davids@dartaero.com>
Cc: <jmurdoch@dartaero.com>
Sent: Wednesday, February 15, 2006 7:26 AM
Subject: 412 x-tube

> hi
> are these dims acceptable to you? the height is good but the tube is over
> bent, and even on the table the jigs are in a little bit on each side.
mail
> me back at my address
> jason murdoch.
>



HeathAir

INTERNATIONAL (1991) INC.

681 Ave. Lepine, Dorval, Québec H9P 1G3
Tél.: (514) 636-1000 • Fax: (514) 636-0031

W.O. N° 33580

A.M.O. Number: 46/90

NON-DESTRUCTIVE TESTING REPORT

AIRCRAFT / COMPONENT INFORMATION

REGISTRATION:

MODEL/TYPE:

SERIAL NUMBER:

TOTAL HR/LDG:

OPERATED BY:

BASED AT:

INSPECTION REQUIREMENTS

Carry out FPI of (3) cross tube (external surface) as per ASTM E-1417-05 and the Dart QSI 038, Section 4.1.1 (on file at client) - parts delivered to HeathAir.

Qty (3) P/N D412-664-203

S/N's B25550, B25551 & B25549



RADIOGRAPHY



ULTRASONIC



PENETRANT



MAGNETIC PARTICLE



EDDY CURRENT

INSPECTION REPORT

Fluorescent penetrant inspection was performed in accordance with the above requirements on (3) cross tubes.

Note: A Level 3 penetrant was substituted for the requested Level 2 (3 is more sensitive)
Ardrox 970P25E Batch #04B503.

(3) cross tubes PASSED inspection.

~~THE MAINTENANCE DESCRIBED ABOVE HAS BEEN PERFORMED IN ACCORDANCE WITH
THE APPLICABLE STANDARDS OF AIRWORTHINESS~~

INSPECTED BY:

DATE February 20, 2006

INSPECTION
STAMP(S) Not Required

CUSTOMER INFORMATION

CUSTOMER: Dart Aerospace

P.O. NUMBER 00000609

ADDRESS:

CONTACT NAME:-

LABOUR

@

\$

MATERIALS

@

TRAVEL EXPENSES

@

GST

HOTEL EXPENSES

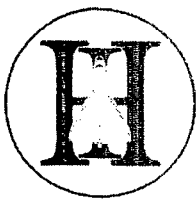
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INVOICE NO.

TOTAL \$

WHITE COPY - INSPECTION FILE • YELLOW COPY - CUSTOMER • PINK COPY - ACCOUNTANT



HeathAir

INTERNATIONAL (1991) INC.

681 Ave. Lepine, Dorval, Québec H9P 1G3
Tél: (514) 636-1000 • Fax: (514) 636-0031

W.O. No **33580**

A.M.O. Number: 46/90

NON-DESTRUCTIVE TESTING REPORT

AIRCRAFT / COMPONENT INFORMATION

REGISTRATION:

MODEL/TYPE:

SERIAL NUMBER:

TOTAL HR/LDG:

OPERATED BY:

BASED AT:

INSPECTION REQUIREMENTS

Carry out FPI of (3) cross tube (external surface) as per ASTM E-1417-05 and the Dart QSI 038, Section 4.1.1 (on file at client) - parts delivered to HeathAir.

Qty (3) P/N D412-664-203 S/N's B25550, B25551 & B25549



RADIOGRAPHY



ULTRASONIC



PENETRANT



MAGNETIC PARTICLE



EDDY CURRENT

INSPECTION REPORT

Fluorescent penetrant inspection was performed in accordance with the above requirements on (3) cross tubes.

Note: A Level 3 penetrant was substituted for the requested Level 2 (3 is more sensitive)
Ardrox 970P25E Batch #04B503.

(3) cross tubes PASSED inspection.

THE MAINTENANCE DESCRIBED ABOVE HAS BEEN PERFORMED IN ACCORDANCE WITH
THE APPLICABLE STANDARDS OF AIRWORTHINESS

INSPECTED BY:

S. FLETCHER

DATE: February 20, 2006

INSPECTION
STAMP(S)

Not Required

CUSTOMER INFORMATION

CUSTOMER: Dart Aerospace

P.O. NUMBER: 00000609

ADDRESS:

CONTACT NAME:

LABOUR @

\$

MATERIALS @

TRAVEL EXPENSES @

GST

HOTEL EXPENSES @

PST

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